























STAUFF Connect

Metric tube connectors, assembly tools
and accessories

Product Catalogue

Version
10/2025



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STAUFF Press Cutting Ring Final Assembly Machine Type SPR-PRC-POC-A-A-IOT



Product Description

The STAUFF Press Assembly Machine SPR-PRC-POC-A-A-IOT allows the pressure/position-controlled final assembly of cutting rings from the Extra-Light Series (LL), the Light Series (L) and the Heavy Series (S) according to ISO 8434-1 / DIN 2353 on tube ends with outer diameters between 4 mm and 42 mm.

The machine is designed as a robust table-top device for continuous operation in the workshop. It is used in connection with hardened and wear-resistant assembly studs FI-FMK and support plates FI-GP which are specially designed for the machine-assisted assembly.

The combined pressure/position-control of the device allows wear on the assembly tools to be detected in time before it can have a negative influence on the assembly result. Maximum service life of the tools is achieved through careful handling of the components and practical operation of the assembly machine. Other factors are proper storage (protected against contamination and corrosion), regular cleaning and lubrication (with suitable lubricants) and thorough preparation of the tube ends before assembly (cutting, deburring and cleaning).

Short times for tool changes, setup and assembly make it possible to carry out series assembly of cutting rings as well as assembly of small and medium quantities with a high level of economic efficiency, reproducibility and process reliability. Among other things, this is achieved with the RFID transponders – which are integrated into the support plates for automatic tool size identification as a standard – and with the tool contact switch: this allows assembly processes to be automatically started and completed by simply pushing the tube end into the assembly stud without having to press any buttons. The assembly area is secured against interference by a light grid to comply with current accident prevention regulations.

With machine-assisted **final assembly**, the cutting ring has already cut 100% into the tube and the fitter only has to tighten the union nut by 30° (corresponds to 1/12 turns) from the fix point. Please pay attention to the corresponding assembly instruction.

Final assembly (100%) minimises the risk for errors (insufficient or excessive manual tightening) and the resulting leak potentials which can often lead to time consuming and expensive machine downtimes and environmental impact. Due to the time benefits during final tightening, final assembly by machine also generates clear saving potentials compared to manual direct assembly as well as to machine-assisted pre-assembly.

In case of incorrect or incomplete assembly where pressure and position parameters significantly deviate from the values stored in the machine, it automatically stops the assembly process and displays a corresponding warning message on the operating panel.

The integrated Cloud connection allows preventive maintenance via remote access and facilitates the documentation of assembly process. For more information please see page 256.



Operating elements of the assembly machine



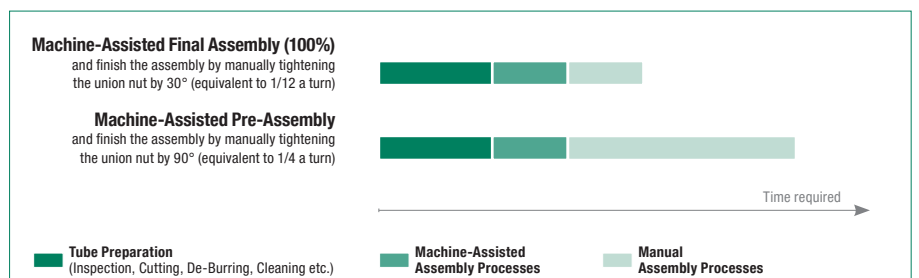
Noise-reducing tool tray with durable rubber mat



Electrical connection plug and Ethernet port (RJ45)



Lateral handle bars and rubber machine feet with suitable clearance height



Comparison of the total times required for the assembly and installation of cutting ring connections (medium size)

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STAUFF Press Cutting Ring Final Assembly Machine Type SPR-PRC-POC-A-A-IOT

Characteristics

Performance

- final assembly (100 %)
- Short times for tool changes, setup and assembly
- Tool size detection via RFID transponders in the support plates
- Automatic assembly start through integrated tool contact switch
- Tool wear detection through combined pressure/position-control
- Internal memory for up to 9 assembly programs which can be selected on the operating panel: predefined are tube materials steel E235 and E355 as well as stainless steel 316; parameters for other materials (copper, CuNiFe, Tungum, polyamide etc.) can be added by the manufacturer if required
- Counters for lot/batch sizes and total quantities (separated by tool size)
- Documented process control through programmable logic control (PLC)
- Predefined menu languages: English, German, French and Italian
- Manual pressure adjustment possible

Design

- ① Robust and ergonomically designed machine housing
- ② Optimised assembly area, which allows processing of tubes with low bending radii (to at least 31 mm distance from the tube axis to the interfering edge of the machine housing) or complex geometries
- ③ Noise-reducing tool tray with durable rubber mat
- ④ Lateral handle bars as attachment points for transport (e.g. with lifting belts)
- ⑤ Secure positioning thanks to flexible rubber machine feet
- ⑥ Type plate, with technical data, serial number, year of manufacture, etc.

Technical Data

Area of Application

- Function: final assembly (100%) of cutting rings on metric tube ends
- Operating principle: Assembly with combined pressure/position-control
- Series and diameters:
 - Extra-Light Series (LL): 4, 6, 8, 10, 12 mm
 - Light Series (L): 6, 8, 10, 12, 15, 18, 22, 28, 35, 42 mm
 - Heavy Series (S): 6, 8, 10, 12, 14, 16, 20, 25, 30, 38 mm

Dimensions / Weight

- Dimensions (W x D x H): 780 mm x 650 mm x 305 mm with lateral handle bars (detachable)
- Distance from the tube axis to the interfering edge of the machine housing: 80 mm
- Clearance height: 65 mm (height of the machine feet) enables simple and safe transport using a forklift or pallet jack
- Weight: 95 kg (incl. operating fluid, excl. assembly tools)

Materials

- Machine frame: Aluminium
- Machine housing: Steel, painted
- Tool tray: NBR (Perbunan®)
- Machine feet: Natural rubber
- Assembly studs: Steel, PVD coated
- Support plates: Steel, browned

Operating Elements

- ⑦ Operating panel for display and selection of all relevant settings and assembly parameters
- ⑧ Button for definite confirmation of entries made on the operating panel
- ⑨ Status light to indicate readiness for operation and running assembly processes

Safety Devices

- ⑩ Main power switch (can be secured against unauthorised actuation when required)
- ⑪ Separate emergency stop button to immediately stop all machine movements
- ⑫ Light grid to protect users when reaching into the assembly area

Connections (at the back of the machine)

- ⑬ Electrical connection according to IEC 60309 CEE 16A (cable length: 4 m) and Ethernet connection (RJ45) for maintenance and data input by the manufacturer

Assembly Tools

- ⑭ Wear-resistant assembly stud FI-MFK
- ⑮ Support plate FI-GP with RFID transponder

Motor Configuration

- Power supply: 400 V AC @ 50 Hz - 3 phases
460 V AC @ 60 Hz - 3 phases
- Current consumption: 2,7 A
- Connected load: 0,9 kW
- Electrical connection: Phase reversing plug according to IEC 60309 CEE 16A
- Cable length: 4 m

Alternative motor configurations and plug types are available on request. Please contact STAUFF for details.

Hydraulic System

- Operating fluid: Hydraulic oil Shell Tellus S2 MA 46 or equivalent (filled and ready for operation when delivered)
- Fluid volume: 4 litres
- Max working pressure: 450 bar

Operating Conditions

- Storage temperature: -10°C ... +70°C
- Ambient temperature: +15°C ... +35°C
- Ambient conditions: Dry, no condensing humidity, operation in horizontal position only
- Noise emission: less than 66 dB(A) as per EN ISO 11202 at full-load operation with maximum tube dimensions



STAUFF Maintenance Contracts

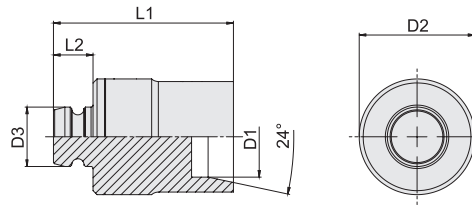
Please contact STAUFF for a maintenance contract, that provides optimum service for your STAUFF assembly machine.



STAUFF Machine Rental

Please contact STAUFF for a rental machine and further details of what this service can offer.

Cutting Ring Assembly Stud for Machine-Assisted Assembly Type FI-MFK ▪ Series LL / L / S



Series	Tube OD mm	Dimensions mm					Weight kg ca. per 100	Ordering Codes
		D1	D2	D3	L1	L2		
LL	4	30	14,8	50	10	12,98	FI-MFK-04LL-W100	
	6	30	14,8	50	10	13,28	FI-MFK-06LL-W100	
	8	30	14,8	50	10	13,68	FI-MFK-08LL-W100	
L	6	30	14,8	50	10	13,57	FI-MFK-06L-W100	
	8	30	14,8	50	10	14,01	FI-MFK-08L-W100	
	10	30	14,8	50	10	14,63	FI-MFK-10L-W100	
	12	30	14,8	50	10	16,09	FI-MFK-12L-W100	
	15	30	14,8	50	10	16,63	FI-MFK-15L-W100	
	18	30	14,8	50	10	18,23	FI-MFK-18L-W100	
	22	30	14,8	49	10	19,13	FI-MFK-22L-W100	
	28	33,8	14,8	48	10	24,43	FI-MFK-28L-W100	
	35	42,8	14,8	45	10	32,72	FI-MFK-35L-W100	
	42	49,8	14,8	44	10	41,17	FI-MFK-42L-W100	
S	6	30	14,8	50	10	14,14	FI-MFK-06S-W100	
	8	30	14,8	50	10	14,68	FI-MFK-08S-W100	
	10	30	14,8	50	10	15,23	FI-MFK-10S-W100	
	12	30	14,8	50	10	15,89	FI-MFK-12S-W100	
	14	30	14,8	49	10	15,98	FI-MFK-14S-W100	
	16	30	14,8	49	10	16,65	FI-MFK-16S-W100	
	20	30	14,8	45	10	16,43	FI-MFK-20S-W100	
	25	33,8	14,8	42	10	19,02	FI-MFK-25S-W100	
	30	39,8	14,8	40	10	22,88	FI-MFK-30S-W100	
38	49,8	14,8	36	10	26,41	FI-MFK-38S-W100		

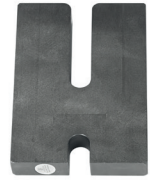
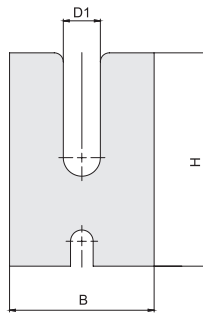
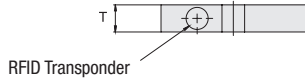
Materials / surface finishings: **W100** Steel, PVD coated

Accessories



Cone Gauges

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Support Plate for Machine-Assisted Assembly
 Type FI-GP ▪ Series LL / L / S


Series	Tube OD mm	Dimensions mm			Weight kg ca. per 100	Ordering Codes
		D1	B	H		
LL	4	80	118	15	104,43	FI-GP-04LL-W101
	6	80	118	15	102,97	FI-GP-06LL-W101
	8	80	118	15	101,46	FI-GP-08LL-W101
L	6	80	118	15	102,97	FI-GP-06L-W101
	8	80	118	15	101,46	FI-GP-08L-W101
	10	80	118	15	99,93	FI-GP-10L-W101
	12	80	118	15	98,35	FI-GP-12L-W101
	15	80	118	15	95,91	FI-GP-15L-W101
	18	80	118	15	93,40	FI-GP-18L-W101
	22	80	118	15	89,91	FI-GP-22L-W101
	28	80	118	15	84,41	FI-GP-28L-W101
	35	80	118	15	77,56	FI-GP-35L-W101
	42	80	118	15	70,27	FI-GP-42L-W101
S	6	80	118	15	102,97	FI-GP-06S-W101
	8	80	118	15	101,46	FI-GP-08S-W101
	10	80	118	15	99,93	FI-GP-10S-W101
	12	80	118	15	98,35	FI-GP-12S-W101
	14	80	118	15	96,73	FI-GP-14S-W101
	16	80	118	15	95,08	FI-GP-16S-W101
	20	80	118	15	91,67	FI-GP-20S-W101
	25	80	118	15	87,20	FI-GP-25S-W101
	30	80	118	15	82,50	FI-GP-30S-W101
	38	80	118	15	74,49	FI-GP-38S-W101

 Materials / surface finishings: **W101** Steel, browned

STAUFF Press
Cloud connection allows preventive maintenance via remote access and facilitates the documentation of assembly processes
Type SPR-PRC-POC-A-A-IOT



Cutting ring assembly machines type SPR-PRC-POC are equipped at the factory with a built-in module for direct connection to a cloud operated by STAUFF. This solution is realised with an integrated SIM card which can be used in all industrial regions of the world.

Customers are given access to the cloud via a protected online portal, where they can get detailed information on the assembly processes performed, among other things.

This enables software updates, for example, without having to connect the machine to a local network on site. Parameter sets, which have been determined by STAUFF for non-standard tube materials can also be transferred quickly and directly to the machine in this way.

The required data security is guaranteed by encryption in both directions.

STAUFF Press
Optional tool holder for tubes with small bending radii
Type SPR-PRC-POC-RTH



The assembly head differs from the standard model by the holder for the cutting ring assembly socket being moved upwards, shortening the distance from the tube axis in the assembly socket to the upper edge of the machine from the standard 77 mm to 31 mm.

The optional assembly head enables tubes with a diameter of 6 to 18 mm in the Light Series and 6 mm to 16 mm in the Heavy Series to be handled.

This means that cutting rings can be fitted with ease to tubes with small axis distances.

Existing assembly tools can also continue to be used. The user simply needs to import new parameter sets into the machine.

If tubes with complex geometries are to be handled (e.g. with short tube end and 90° tail), the safety light barrier, which secures the assembly area, can be disabled if required.

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Assembly Tool Magazine
Type SPR-TM

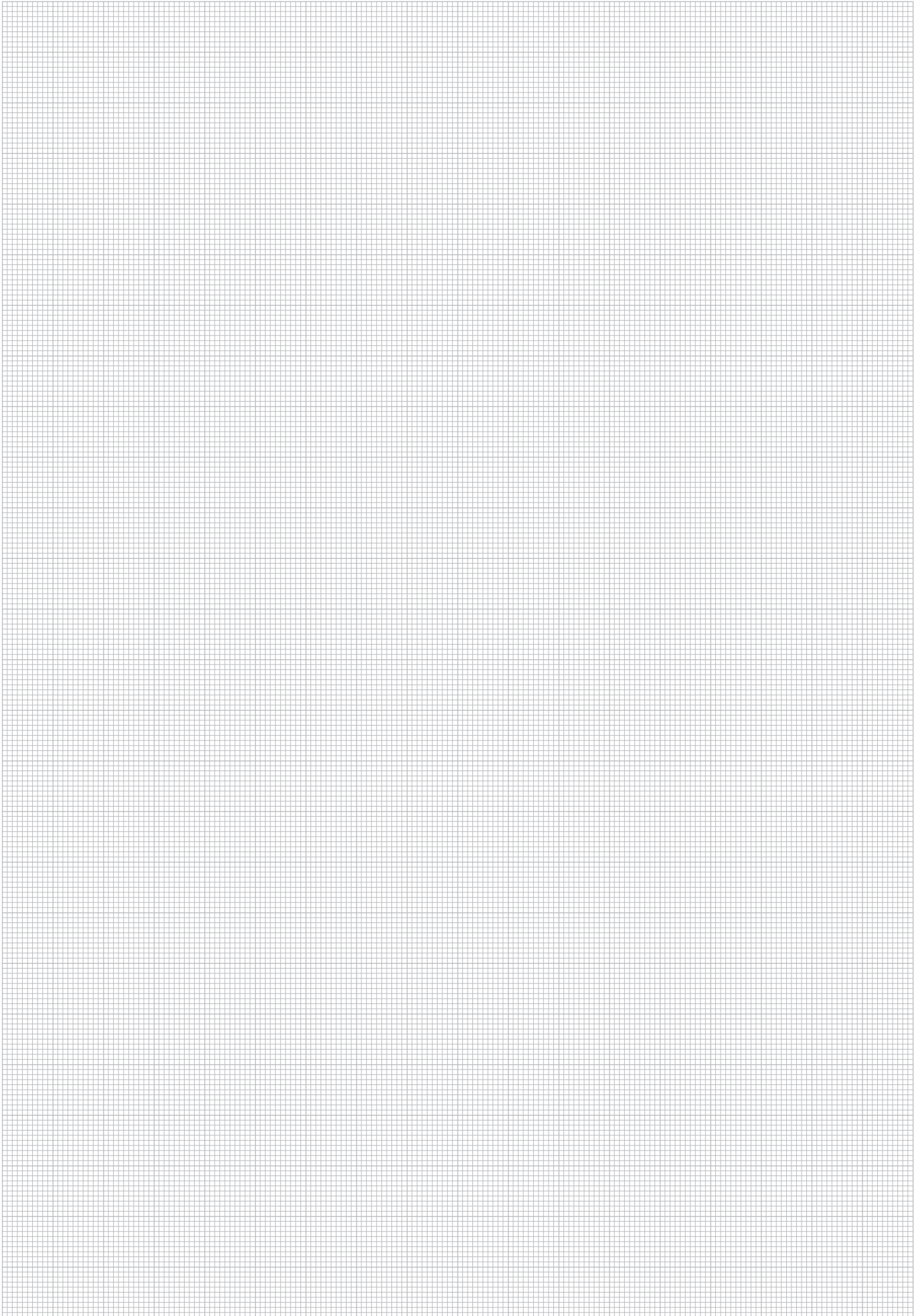


- Provides safe and convenient storage for up to 10 assembly studs (type FI-MFK) as well as up to 10 support plates (types FI-GP and FI-GP-PRC) for the machine-assisted cutting ring assembly
- Assembly studs and support plates are not included in the scope of delivery for this item and have to be ordered separately

External Foot Control Switch
Type SFO/PRC-POC-FS



- Enables the operator to trigger assembly processes from a larger distance to the machine (cable length: 7 m)



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STAUFF Press Combined Cutting Ring Assembly and 37° Tube Flaring Machine with Automatic or Manual Pressure Setting and Control ▪ Type SPR-PRC-MA-D-A

Product Description

The electro-hydraulically operated STAUFF Press Assembly Machine SPR-PRC-MA-D-A allows the assembly of cutting rings in the Light Series (L) as well as in the Heavy Series (S) according to ISO 8434-1 / DIN 2353 on metric tube ends with outer diameters from 4 mm to 42 mm.

Exchangeable heads allows the device to be adapted for 37° flaring of metric and imperial tube ends with outer diameters from 4 mm to 42 mm and from 1/4 in to 1 1/2 in respectively according to DIN 3949 or SAE J514 / ISO 8434-2.

Short times for tool changes, setup and assembly (even when changing the assembly type from cutting ring assembly to 37° tube flaring) make it possible to carry out series production as well as the assembly of small and medium quantities with a high level of economic efficiency, reproducibility and process reliability with considerable reduction of times and cost of assembly of fittings.

The adjustable return stroke of the cylinder helps the operator to further optimise the total cycle times.

The machine is designed as a robust table-top device for continuous operation in the workshop. It is used in connection with hardened and wear-resistant assembly tools which are specially designed for the machine-assisted assembly.



Tooling head for cutting ring assembly based on pre-defined settings / automatic tool size detection



Tooling head for cutting ring assembly based on settings manually defined by the operator



Tooling head for 37° tube flaring based on settings manually defined by the operator



Smart programmable control panel with push/turn button and back-lit parameter display



Noise-reducing tool tray with durable rubber mat



Robust rubber feet providing secure positioning and dampening during operation



USB connection for maintenance and data input by the manufacturer



Electrical connection with a phase reversing plug according to IEC 60309 CEE 16A



Connections for the tool head as well as for the external foot control switch

STAUFF Press

Combined Cutting Ring Assembly and 37° Tube Flaring Machine with Automatic or Manual Pressure Setting and Control ▪ Type SPR-PRC-MA-D-A

Characteristics

Performance

- Pressure-controlled assembly of cutting rings on metric tube ends as well as 37° tube flaring of metric/imperial tube ends due to exchangeable tool heads
- Cutting ring assembly with Tooling Head SPR-PRC-TH-C-MA based on pre-defined pressure settings (with automatic tool size detection) or with Tooling Head SPR-PRC-TH-C-M based on pressure settings as manually defined by the operator
- Short times for tool and head changes, setup and assembly (even when changing the assembly type from cutting ring assembly to 37° tube flaring)
- Adjustable return stroke of the cylinder in order to further optimise the total cycle times
- Internal memory for up to 8 assembly programs which can be selected on the operating panel: predefined are tube materials steel E235 and E355 as well as stainless steel 316; parameters for other materials (copper, CuNiFe, Tungum, polyamide etc.) can be added by the manufacturer if required
- Counters for lot/batch sizes and total quantities
- Operator-friendly and easy to maintain and service

Design

- ① Robust and compact table-top device allowing for maximum mobility and flexibility
- ② Optimised assembly area with approx. 65 mm distance from the tube axis to the interfering edge of the machine housing, which allows processing of tubes with low bending radii or complex geometries
- ③ Noise-reducing tool tray with durable rubber mat
- ④ Lateral handle bars as attachment points for transport (e.g. with lifting belts)
- ⑤ Robust rubber feet providing secure positioning and dampening during operation
- ⑥ Type plate, with technical data, serial number, year of manufacture, etc.

Technical Data

Area of Application

- Function: Pressure-controlled assembly of cutting rings
Light (L): 6, 8, 10, 12, 15, 18, 22, 28, 35, 42 mm
Heavy (S): 6, 8, 10, 12, 14, 16, 20, 25, 30, 38 mm
- Pressure-controlled 37° flaring of metric tube ends (according to DIN 3949 bzw. SAE J 514 / ISO 8434-2):
Light (L): from 6 x 1 mm to 42 x 4 mm
Heavy (S): from 6 x 1 mm to 38 x 5 mm
- Pressure-controlled 37° flaring of imperial tube ends (according to SAE J 514 / ISO 8434-2):
1/4, 5/16, 3/8, 1/2, 5/8, 3/4, 7/8, 1, 1-1/4, 1-1/2 inch

Dimensions / Weight

- Dimensions (W x D x H): 660 mm x 515 mm x 265 mm with lateral handle bars (detachable)
- Distance from the tube axis to the interfering edge of the machine housing: 65 mm
- Clearance height: 30 mm (height of the machine feet)
- Weight (basic machine): 66 kg (incl. operating fluid, excl. assembly tools)
- Weight (tooling heads):
SPR-PRC-TH-C-A: 6,0 kg
SPR-PRC-TH-C-M: 5,5 kg
SPR-PRC-TH-F-M: 19,5 kg

Materials

- Machine frame: Steel
- Machine cover: Plastic
- Tool tray: NBR (Perbunan®)
- Machine feet: Natural rubber
- Assembly tools: Steel, uncoated, hardened

Operating Elements

- ⑦ Push/turn control button to select all relevant settings and assembly parameters
- ⑧ Smart programmable control panel with back-lit parameter display
- ⑨ Button for definite confirmation of entries made on the operating panel
- ⑩ Illuminated pushbutton to reset the cylinder and to indicate incorrect assemblies

Safety Devices

- ⑪ Selector switch to choose the operation mode (can be locked with a key and secured against unauthorised actuation, if required)
- ⑫ Main power switch
- ⑬ Separate emergency stop button to immediately stop all machine movements

Connections

- ⑭ Electrical connection according to IEC 60309 CEE 16A (cable length: 4 m)
- ⑮ USB connection for maintenance and data input by the manufacturer
- ⑯ Connections for tool heads for cutting ring assembly based on pre-defined pressure settings as well as for the external foot control switch SPR-PRC-FS (available on request)

Assembly Tools

- Tooling head SPR-PRC-TH-C-MA for cutting ring assembly based on automatic pressure setting (Pre-assembly is pre-defined) and with tool size detection via the support plates
- Tooling head SPR-PRC-TH-C-M for cutting ring assembly based on manual settings
- Tooling head SPR-PRC-TH-F-M for 37° tube flaring based on manual settings
- Wear-resistant cutting ring assembly stud FI-MFK
- Support plate FI-GP-...-PRC
- Clamping jaws FI-KB-...-PRC for 37° tube flaring

Motor Configuration

- Power supply: 400 V AC @ 50 Hz - 3 phases
- Current consumption: 2,8 A
- Connected load: 1,2 kW
- Electrical connection: Phase reversing plug according to IEC 60309 CEE 16A
- Cable length: 4 m

Alternative motor configurations and plug types are available on request. Please contact STAUFF for details.

Hydraulic System

- Operating fluid: Hydraulic oil Shell Nuto H 32 or equivalent (filled and ready for operation when delivered)
- Fluid volume: 4 litres
- Max working pressure: 200 bar

Operating Conditions

- Storage temperature: -10°C ... +70°C
- Ambient temperature: +10°C ... +50°C
- Ambient conditions: Dry, no condensing humidity, operation in horizontal position only
- Noise emission: less than 60 dB(A) as per EN ISO 11202



STAUFF Maintenance Contracts

Please contact STAUFF for a maintenance contract, that provides optimum service for your STAUFF assembly machine.



STAUFF Machine Rental

Please contact STAUFF for a rental machine and further details of what this service can offer.

Tooling Head for Cutting Ring Assembly (based on pre-defined settings)

Type SPR-PRC-TH-C-MA



- Tooling head SPR-PRC-TH-C-MA for cutting ring pre-assembly based on pre-defined settings and with automatic tool size detection via the support plates
- Requires cutting ring assembly studs FI-MFK and support plates FI-GP-PRC

Tooling Head for Cutting Ring Assembly (based on manual settings)

Type SPR-PRC-TH-C-M



- Tooling head SPR-PRC-TH-C-M for cutting ring pre-assembly based on manual settings
- Requires cutting ring assembly studs FI-MFK and support plates FI-GP-PRC

Tooling Head for 37° Tube Flaring (based on manual settings)

Type SPR-PRC-TH-F-M



- Tooling head SPR-PRC-TH-F-M for 37° tube flaring based on manual settings
- Requires clamping jaws FI-KB-PRC

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Assembly Tool Magazine

Type SPR-TM



- Provides safe and convenient storage for up to 10 assembly studs (type FI-MFK) as well as up to 10 support plates (types FI-GP and FI-GP-PRC) for the machine-assisted cutting ring assembly
- Assembly studs and support plates are not included in the scope of delivery for this item and have to be ordered separately

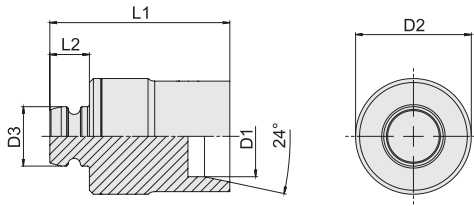
External Foot Control Switch

Type SPR-PRC-FS



- Enables the operator to trigger assembly processes from a larger distance to the machine (cable length: 5 m)

Cutting Ring Assembly Stud for Machine-Assisted Assembly Type FI-MFK • Series LL / L / S



Series	Tube OD mm	Dimensions mm				Weight kg ca. per 100	Ordering Codes
		D1	D2	D3	L1		
L	6	30	14,8	50	10	13,57	FI-MFK-06L-W100
	8	30	14,8	50	10	14,01	FI-MFK-08L-W100
	10	30	14,8	50	10	14,63	FI-MFK-10L-W100
	12	30	14,8	50	10	16,09	FI-MFK-12L-W100
	15	30	14,8	50	10	16,63	FI-MFK-15L-W100
	18	30	14,8	50	10	18,23	FI-MFK-18L-W100
	22	30	14,8	49	10	19,13	FI-MFK-22L-W100
	28	33,8	14,8	48	10	24,43	FI-MFK-28L-W100
	35	42,8	14,8	45	10	32,72	FI-MFK-35L-W100
	42	49,8	14,8	44	10	41,17	FI-MFK-42L-W100
S	6	30	14,8	50	10	14,14	FI-MFK-06S-W100
	8	30	14,8	50	10	14,68	FI-MFK-08S-W100
	10	30	14,8	50	10	15,23	FI-MFK-10S-W100
	12	30	14,8	50	10	15,89	FI-MFK-12S-W100
	14	30	14,8	49	10	15,98	FI-MFK-14S-W100
	16	30	14,8	49	10	16,65	FI-MFK-16S-W100
	20	30	14,8	45	10	16,43	FI-MFK-20S-W100
	25	33,8	14,8	42	10	19,02	FI-MFK-25S-W100
	30	39,8	14,8	40	10	22,88	FI-MFK-30S-W100
	38	49,8	14,8	36	10	26,41	FI-MFK-38S-W100

Materials / surface finishings: **W100** Steel, PVD coated

Accessories



Cone Gauges

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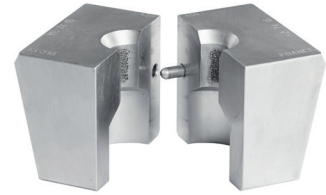
Support Plate for Machine-Assisted Cutting Ring Assembly
Type FI-GP-PRC • Series L / S



Series	Tube OD mm	Ordering Codes
L	6	FI-GP-06L/S-PRC-MA-W1
	8	FI-GP-08L/S-PRC-MA-W1
	10	FI-GP-10L/S-PRC-MA-W1
	12	FI-GP-12L/S-PRC-MA-W1
	15	FI-GP-15L-PRC-MA-W1
	18	FI-GP-18L-PRC-MA-W1
	22	FI-GP-22L-PRC-MA-W1
	28	FI-GP-28L-PRC-MA-W1
	35	FI-GP-35L-PRC-MA-W1
	42	FI-GP-42L-PRC-MA-W1
S	6	FI-GP-06L/S-PRC-MA-W1
	8	FI-GP-08L/S-PRC-MA-W1
	10	FI-GP-10L/S-PRC-MA-W1
	12	FI-GP-12L/S-PRC-MA-W1
	14	FI-GP-14S-PRC-MA-W1
	16	FI-GP-16S-PRC-MA-W1
	20	FI-GP-20S-PRC-MA-W1
	25	FI-GP-25S-PRC-MA-W1
	30	FI-GP-30S-PRC-MA-W1
	38	FI-GP-38S-PRC-MA-W1

Materials / surface finishings: **W1** Steel, uncoated, hardened

Clamping Jaws for 37° Tube Flaring Type FI-KB • Series L / S



37° Flaring of Metric Tube Ends

Series	Tube OD mm	Ordering Codes		
		DIN 3949	SAE J514 / ISO 8434-2	
L	6	FI-KB-06L/S-PRC-MF-W1	FI-KB-06-PRC-F-W1	
	8	FI-KB-08L/S-PRC-MF-W1	FI-KB-08/5/16-PRC-F-W1	
	10	FI-KB-10L/S-PRC-MF-W1	FI-KB-10-PRC-F-W1	
	12	FI-KB-12L/S-PRC-MF-W1	FI-KB-12-PRC-F-W1	
	15	FI-KB-15L-PRC-MF/F-W1		
	18	FI-KB-18L-PRC-MF/F-W1		
	22	FI-KB-22L-PRC-MF/F-W1		
	28	FI-KB-28L-PRC-MF-W1	FI-KB-28-PRC-F-W1	
	35	FI-KB-35L-PRC-MF-W1	FI-KB-35-PRC-F-W1	
	42	FI-KB-42L-PRC-MF-W1	FI-KB-42-PRC-F-W1	
	S	6	FI-KB-06L/S-PRC-MF-W1	FI-KB-06-PRC-F-W1
		8	FI-KB-08L/S-PRC-MF-W1	FI-KB-08/5/16-PRC-F-W1
10		FI-KB-10L/S-PRC-MF-W1	FI-KB-10-PRC-F-W1	
12		FI-KB-12L/S-PRC-MF-W1	FI-KB-12-PRC-F-W1	
14		FI-KB-14S-PRC-MF/F-W1		
16		FI-KB-16S-PRC-MF-W1	FI-KB-16-PRC-F-W1	
20		FI-KB-20S-PRC-MF-W1	FI-KB-20-PRC-F-W1	
25		FI-KB-25S-PRC-MF-W1	FI-KB-25-PRC-F-W1	
30		FI-KB-30S-PRC-MF/F-W1		
30 x 5		FI-KB-30SX5-PRC-MF-W1	FI-KB-38/1-1/2-PRC-F-W1	
38		FI-KB-38S-PRC-MF-W1		
38 x 5		FI-KB-38SX5-PRC-MF-W1		

37° Flaring of Imperial Tube Ends

Tube OD mm	Ordering Codes
	SAE J514 / ISO 8434-2
1/4	FI-KB-1/4-PRC-F-W1
5/16	FI-KB-08/5/16-PRC-F-W1
3/8	FI-KB-3/8-PRC-F-W1
1/2	FI-KB-1/2-PRC-F-W1
5/8	FI-KB-5/8-PRC-F-W1
3/4	FI-KB-3/4-PRC-F-W1
7/8	FI-KB-7/8-PRC-F-W1
1	FI-KB-1-PRC-F-W1
1-1/4	FI-KB-1-1/4-PRC-F-W1
1-1/2	FI-KB-38/1-1/2-PRC-F-W1

Materials / surface finishings: W1 Steel, uncoated, hardened

STAUFF Press Portable Cutting Ring Assembly Machine with Manual Pressure Setting (Set) Type SPR-PRC-H-E-SET

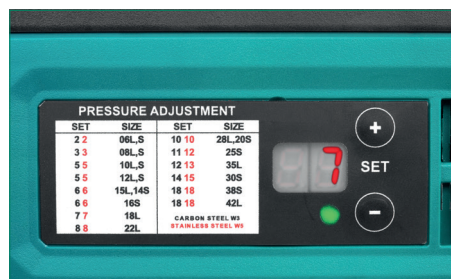
Product Description

With the battery-operated STAUFF Press Assembly Machine SPR-PRC-H-E-SET, STAUFF provides an ergonomically designed, light-weight and at the same time robust device for the assembly of cutting rings made of Carbon Steel and Stainless Steel in the Light Series (L) as well as in the Heavy Series (S) according to ISO 8434-1 / DIN 2353 on metric tube ends with outer diameters from 6 mm to 42 mm.

The machine has been designed for hand-held, tripod- or table-mounted operation and offers the best technical compromise between maximum flexibility, economic efficiency and a high level of process reliability with considerable reduction of time and cost for the assembly of cutting ring fittings.

Short tool change and setup times (with only a few seconds required to manually adjust the assembly pressure) make it possible to carry out the assembly of medium and even small quantities of cutting ring fittings, e.g. during maintenance, servicing, conversion and repair works on hydraulic pipe and tube systems. With the rechargeable battery being able to typically cover more than 200 assembly cycles per charge (depending on pressure settings and other influencing factors), the machine is also suitable for mass processing and production.

The assembly machine is by default supplied in a heavy-duty trolley transport case that is equipped with a range of accessories and also provides suitable space for the assembly studs.



Operating element to adjust the pressure setting (settings indicated on the machine housing) incl. status lights



Assembly machine attached to a tripod stand using a mounting bracket



Heavy-duty trolley transport case



STAUFF Press Portable Cutting Ring Assembly Machine with Manual Pressure Setting (Set) Type SPR-PRC-H-E-SET

Technical Data

Area of Application

- Function: Pressure-controlled assembly of cutting rings made of Carbon Steel and Stainless Steel acc. to ISO 8434-1 / DIN 2353 on metric tube ends
Light (L): 6, 8, 10, 12, 15, 18, 22, 28, 35 and 42 mm
Heavy (S): 6, 8, 10, 12, 14, 16, 20, 25, 30 and 38 mm

Dimensions / Weight

- Dimensions (L x H x W): 440 mm x 330 mm x 80 mm
(including rechargeable battery)
- Weight (basic machine): 6,9 kg
(including rechargeable battery)
- Weight (case): 16,6 kg
(including assembly machine and accessories)
- Case: IP67 certified, equipped with o-ring seal and automatic pressure valve

Materials

- Machine cover: Plastic
- Tool head: Steel, uncoated, hardened
- Assembly studs: Stainless steel, hardened

List of Components

Set supplied in a heavy-duty trolley transport case:

- ① Light-weight and ergonomically designed cutting ring assembly machine for the hand-held, tripod-mounted or table-mounted operation
- ② Rechargeable battery
- ③ Additional replacement battery
- ④ Battery quick charging unit
- ⑤ Clips (to keep the assembly stud in position)
- ⑥ Assembly oil with brush (to lubricate the taper of the assembly stud)
- ⑦ Shoulder strap

Equipment to be ordered separately:

- ⑧ Cutting Ring Assembly Studs **FI-MVK-PRC-H-M-HR**

Spare Parts

- Assembly oil with brush **SPR-PRC-H-M-OS**
(required to lubricate the taper of the assembly stud)
- Rechargeable Battery **SPR-PRC-H-M-BP**
- Battery Quick Charging Unit **SPR-PRC-H-M-BC**

Rechargeable Battery

- Typically covers more than 200 assembly cycles per charge (depending on pressure settings and other influencing factors)
- Battery type: Lithium-ion (18V / 5.0 Ah)

Charging Unit

- Charging time for empty batteries is approximately 75 minutes
- Power supply: 230 V AC @ 50 Hz - single-phase
- Electrical connection: 2-pin grounded safety plug (CEE 7/4, type F / Schuko)
- Cable length: 1,10m

Accessories



- Tripod Stand **SPR-PRC-H-M-TP**



- Table Stand **SPR-PRC-H-M-TS**



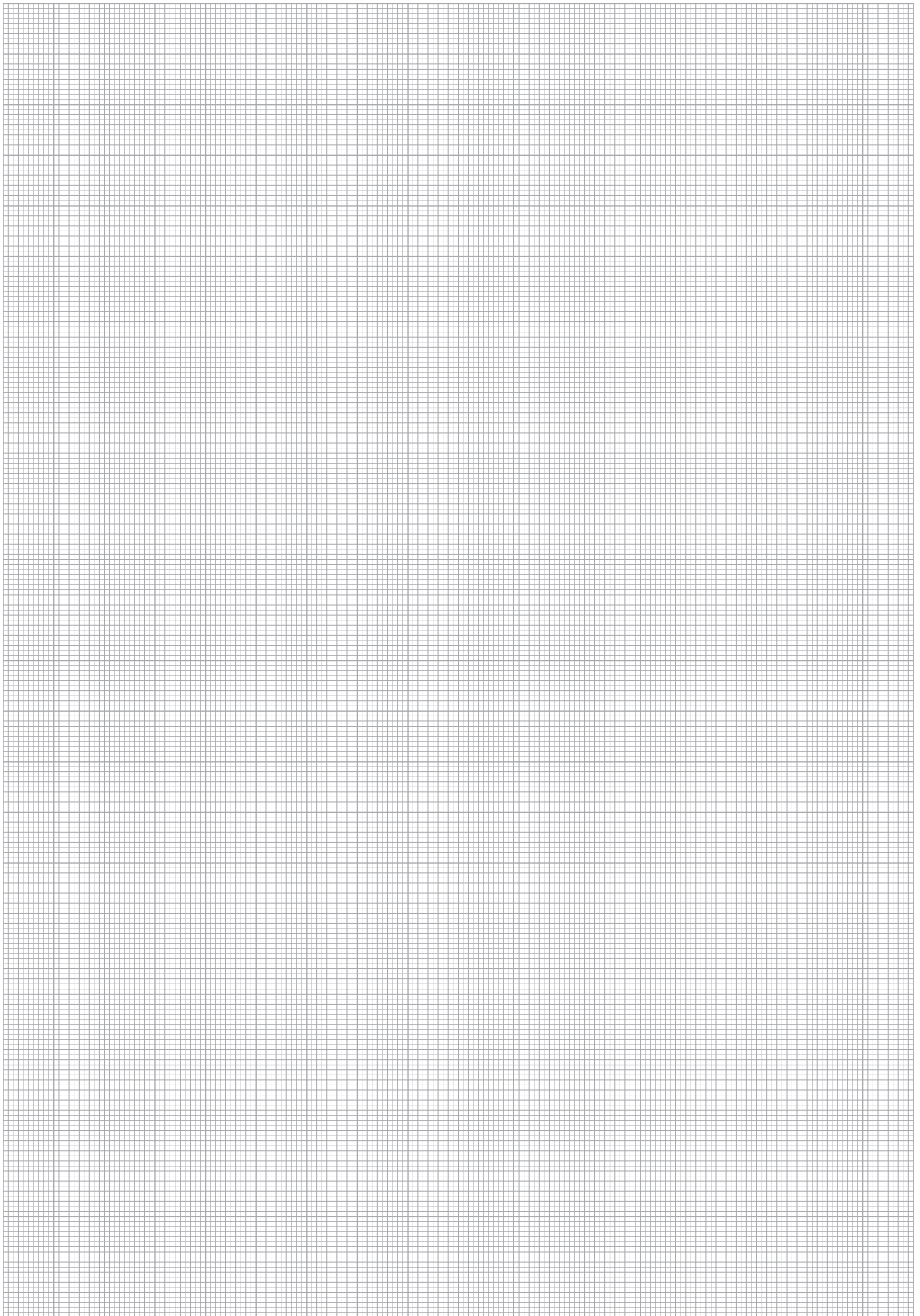
- Mounting Bracket **SPR-PRC-H-M-MH**
(required as a machine holder for both the tripod stand and the table stand)

Cutting Ring Assembly Stud for Machine-Assisted Assembly
Type FI-MVK-PRC-H-M ▪ Series L / S



Series	Tube OD mm	Ordering Codes
L	6	FI-MVK-06L-PRC-H-M-HR
	8	FI-MVK-08L-PRC-H-M-HR
	10	FI-MVK-10L-PRC-H-M-HR
	12	FI-MVK-12L-PRC-H-M-HR
	15	FI-MVK-15L-PRC-H-M-HR
	18	FI-MVK-18L-PRC-H-M-HR
	22	FI-MVK-22L-PRC-H-M-HR
	28	FI-MVK-28L-PRC-H-M-HR
	35	FI-MVK-35L-PRC-H-M-HR
	42	FI-MVK-42L-PRC-H-M-HR
S	6	FI-MVK-06S-PRC-H-M-HR
	8	FI-MVK-08S-PRC-H-M-HR
	10	FI-MVK-10S-PRC-H-M-HR
	12	FI-MVK-12S-PRC-H-M-HR
	14	FI-MVK-14S-PRC-H-M-HR
	16	FI-MVK-16S-PRC-H-M-HR
	20	FI-MVK-20S-PRC-H-M-HR
	25	FI-MVK-25S-PRC-H-M-HR
	30	FI-MVK-30S-PRC-H-M-HR
	38	FI-MVK-38S-PRC-H-M-HR

Materials / surface finishing: **HR** Stainless steel, hardened



P

Manual Cutting Ring Pre-Assembly Device Type SPR-PRC-MP

Product Description

The manual cutting ring pre-assembly device can be used to pre-assemble hydraulic lines made of steel and stainless steel with an outer diameter of 6 - 42 mm.

For flexible use on site, the tool is supplied in a robust steel case. In the case there is also space for STAUFF cutting ring assembly studs type FI-MFK and support plates type FI-GP-PRC. These are not included in the scope of delivery, but can be purchased separately.



Product Features

- Pressure-controlled, manual assembly of steel and stainless steel cutting rings (ISO 8434-1 / DIN 2353) on metric tube ends from 6 to 42 mm in the light series and 6 to 38 mm in the heavy series
- For cutting rings of the FI-DS, FI-WDDS and FI-WDDS-W5 series
- Pressure values can be read on the device and precisely adjustable via manometer
- incl. robust steel case with storage space for accessories
- Ideally suited for flexible on-site use, e.g. for installation on the construction site without a power supply

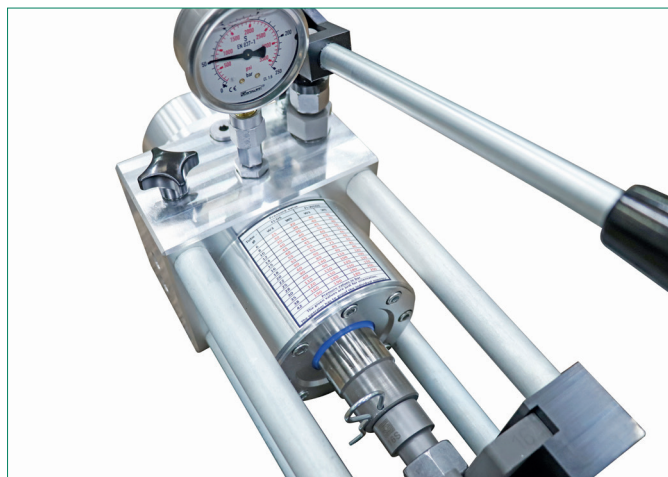
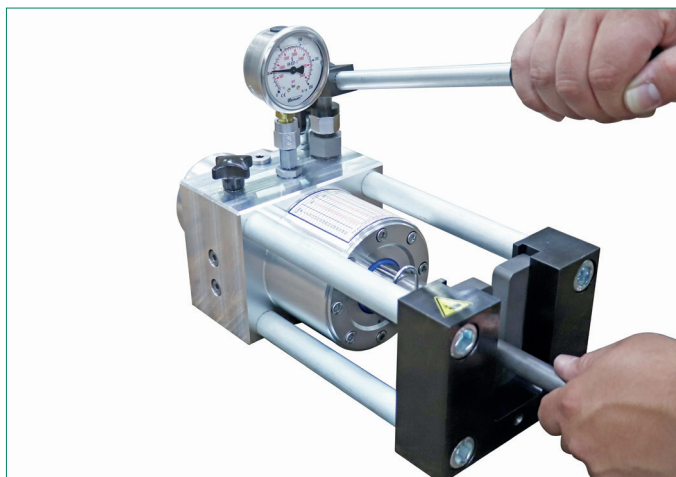
Ordering Code

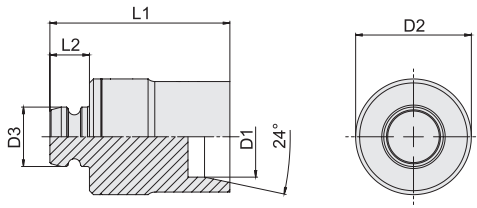
- Manual Cutting Ring Pre-Assembly Device

SPR-PRC-MP

Technical Data

- Dimensions W x D x H (incl. Case):
435,7 mm x 253 mm x 150 mm
(750 mm x 335 mm x 175 mm)
- Weight (incl. Case):
15 kg (23 kg)



**Cutting Ring Assembly Stud for Manual Assembly
Type FI-MFK • Series LL / L / S**


Series	Tube OD mm	Dimensions mm				Weight kg ca. per 100	Ordering Codes
		D1	D2	D3	L1		
L	6	30	14,8	50	10	13,57	FI-MFK-06L-W100
	8	30	14,8	50	10	14,01	FI-MFK-08L-W100
	10	30	14,8	50	10	14,63	FI-MFK-10L-W100
	12	30	14,8	50	10	16,09	FI-MFK-12L-W100
	15	30	14,8	50	10	16,63	FI-MFK-15L-W100
	18	30	14,8	50	10	18,23	FI-MFK-18L-W100
	22	30	14,8	49	10	19,13	FI-MFK-22L-W100
	28	33,8	14,8	48	10	24,43	FI-MFK-28L-W100
	35	42,8	14,8	45	10	32,72	FI-MFK-35L-W100
	42	49,8	14,8	44	10	41,17	FI-MFK-42L-W100
S	6	30	14,8	50	10	14,14	FI-MFK-06S-W100
	8	30	14,8	50	10	14,68	FI-MFK-08S-W100
	10	30	14,8	50	10	15,23	FI-MFK-10S-W100
	12	30	14,8	50	10	15,89	FI-MFK-12S-W100
	14	30	14,8	49	10	15,98	FI-MFK-14S-W100
	16	30	14,8	49	10	16,65	FI-MFK-16S-W100
	20	30	14,8	45	10	16,43	FI-MFK-20S-W100
	25	33,8	14,8	42	10	19,02	FI-MFK-25S-W100
	30	39,8	14,8	40	10	22,88	FI-MFK-30S-W100
	38	49,8	14,8	36	10	26,41	FI-MFK-38S-W100

 Materials / surface finishings: **W100** Steel, PVD coated

Accessories


Cone Gauges

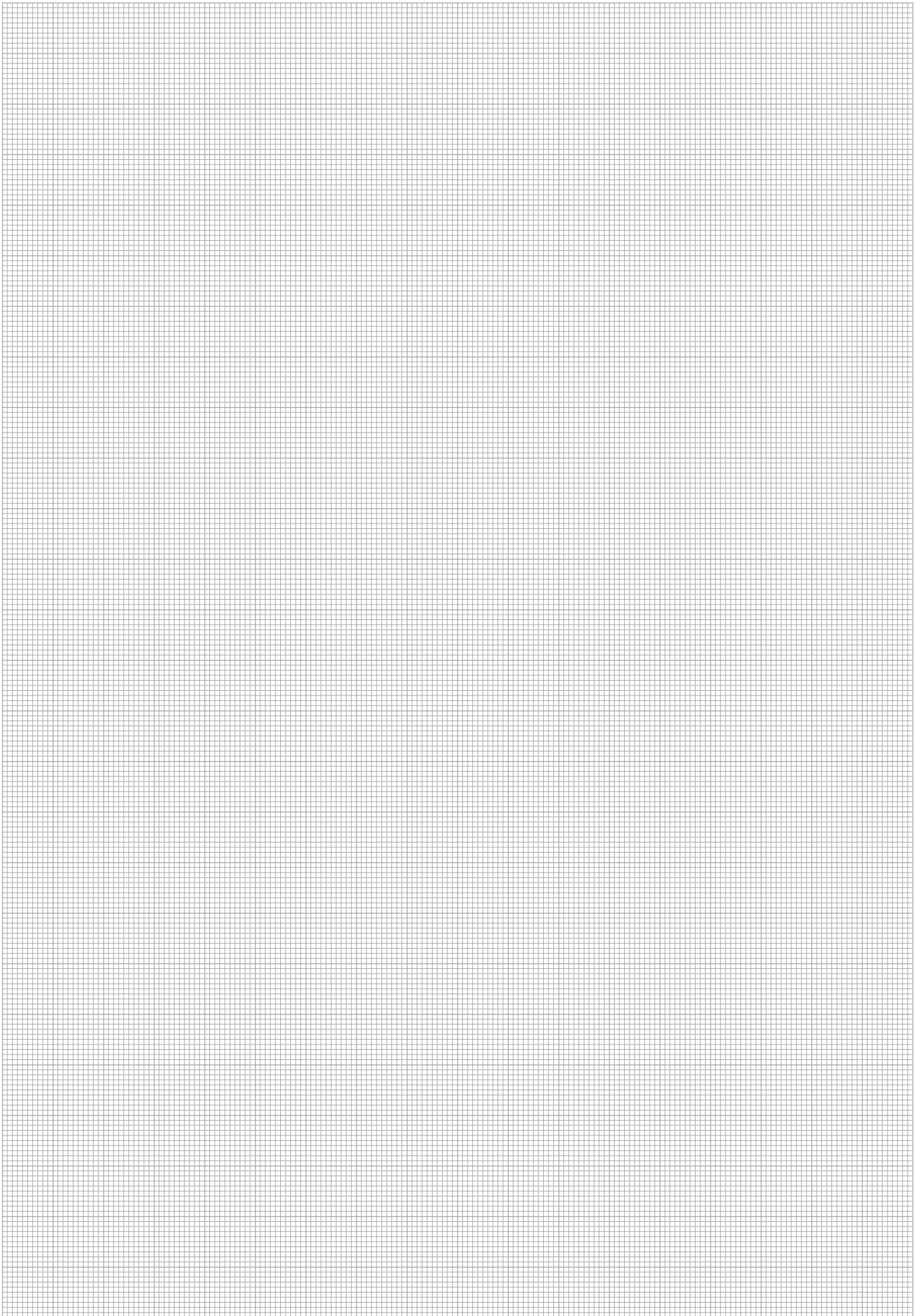
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Support Plate for Manual Cutting Ring Assembly
Type FI-GP-PRC • Series L / S

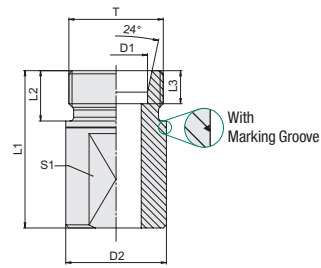


Series	Tube OD mm	Ordering Codes
L	6	FI-GP-06L/S-PRC-MA-W1
	8	FI-GP-08L/S-PRC-MA-W1
	10	FI-GP-10L/S-PRC-MA-W1
	12	FI-GP-12L/S-PRC-MA-W1
	15	FI-GP-15L-PRC-MA-W1
	18	FI-GP-18L-PRC-MA-W1
	22	FI-GP-22L-PRC-MA-W1
	28	FI-GP-28L-PRC-MA-W1
	35	FI-GP-35L-PRC-MA-W1
	42	FI-GP-42L-PRC-MA-W1
S	6	FI-GP-06L/S-PRC-MA-W1
	8	FI-GP-08L/S-PRC-MA-W1
	10	FI-GP-10L/S-PRC-MA-W1
	12	FI-GP-12L/S-PRC-MA-W1
	14	FI-GP-14S-PRC-MA-W1
	16	FI-GP-16S-PRC-MA-W1
	20	FI-GP-20S-PRC-MA-W1
	25	FI-GP-25S-PRC-MA-W1
	30	FI-GP-30S-PRC-MA-W1
	38	FI-GP-38S-PRC-MA-W1

Materials / surface finishings: **W1** Steel, uncoated, hardened



Final Assembly Stud for the Manual Cutting Ring Assembly Type FI-FK • Series LL / L / S



Series	Tube OD mm	Dimensions mm						Weight kg ca. per 100	Ordering Codes
		D1	Thread T	D2	L1	L2	L3		
LL	4	M 8 x 1	14	40	8	4	11	3,74	FI-FK-04LL-HR
	6	M 10 x 1	14	40	8	5,5	11	3,81	FI-FK-06LL-HR
	8	M 12 x 1	14	41	9	5,5	11	4,00	FI-FK-08LL-HR
L	6	M 12 x 1,5	14	43	10	7	11	4,21	FI-FK-06L-HR
	8	M 14 x 1,5	15	43	10	7	12	4,96	FI-FK-08L-HR
	10	M 16 x 1,5	17	44	11	7	14	6,57	FI-FK-10L-HR
	12	M 18 x 1,5	20	44	11	7	17	9,06	FI-FK-12L-HR
	15	M 22 x 1,5	23	45	12	7	19	12,34	FI-FK-15L-HR
	18	M 26 x 1,5	29	46	12	7,5	24	19,62	FI-FK-18L-HR
	22	M 30 x 2	32	48	14	7,5	27	25,11	FI-FK-22L-HR
	28	M 36 x 2	38	48	14	7,5	32	35,07	FI-FK-28L-HR
	35	M 45 x 2	48	60	16	10,5	41	69,87	FI-FK-35L-HR
	42	M 52 x 2	54	60	16	11	46	87,41	FI-FK-42L-HR
S	6	M 14 x 1,5	15	45	12	7	12	5,34	FI-FK-06S-HR
	8	M 16 x 1,5	17	45	12	7	14	6,92	FI-FK-08S-HR
	10	M 18 x 1,5	20	45	12	7,5	17	9,44	FI-FK-10S-HR
	12	M 20 x 1,5	22	45	12	7,5	17	10,87	FI-FK-12S-HR
	14	M 22 x 1,5	24	47	14	8	19	13,59	FI-FK-14S-HR
	16	M 24 x 1,5	27	48	14	8,5	22	17,49	FI-FK-16S-HR
	20	M 30 x 2	32	50	16	10,5	27	25,83	FI-FK-20S-HR
	25	M 36 x 2	38	62	18	12	32	46,15	FI-FK-25S-HR
30	M 42 x 2	44	64	20	13,5	36	62,34	FI-FK-30S-HR	
38	M 52 x 2	54	66	22	16	46	95,92	FI-FK-38S-HR	

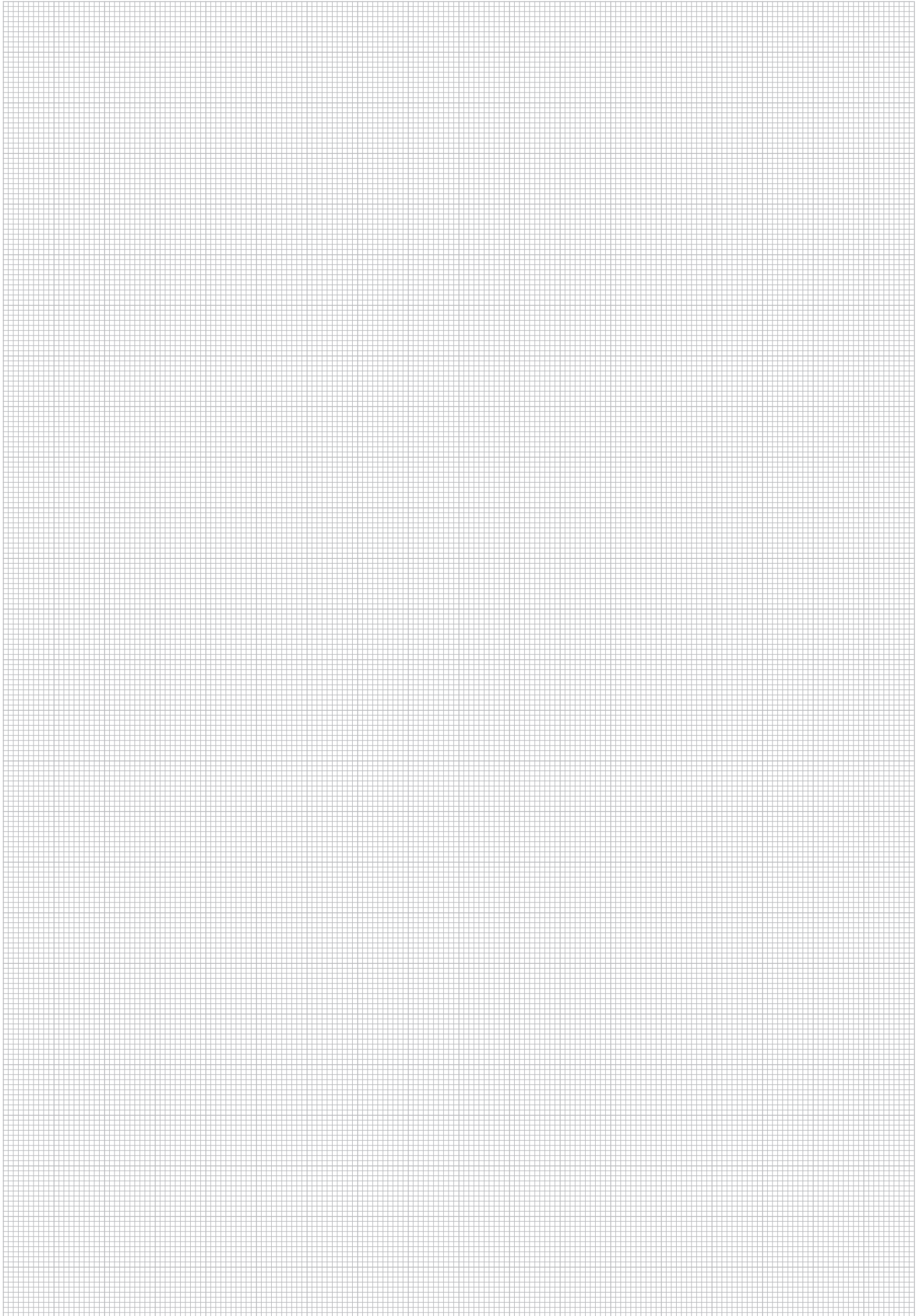
Materials / surface finishings: HR Steel, uncoated, hardened

Accessories



Cone Gauges

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P

STAUFF Form EVO Tube Forming Machine Type SFO-F-A-A-IOT



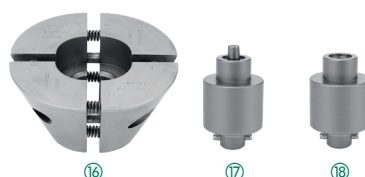
Product Description

The type SFO-F-A-A-IOT tube forming machine facilitates the economical and most reliable production of tube ends made of steel, stainless steel and other materials with a contour typical for the STAUFF Form EVO tube forming system.

The machine is designed as a robust table-top device for continuous operation in the workshop. It is used in connection with FI-FST tube shapers and FI-FB clamping jaws. Tube shapers with FI-ID internal tube supports are used with selected tube dimensions, which prevent the tube from being constricted in the shaping area.

Tube shapers, clamping jaws and internal tube supports have been specifically designed for the mechanical forming process and can be quickly and simply replaced without the need for any tools, if required. The resulting short tool change and set-up times contribute to the high efficiency of the system as well as ensuring low cycle times.

All the tools needed for the forming process are clearly labelled with the tube dimensions so that assembly errors caused by incorrect assignment can be largely ruled out.



**STAUFF Form EVO Sealing Ring
Type FI-FD, see Page 32**



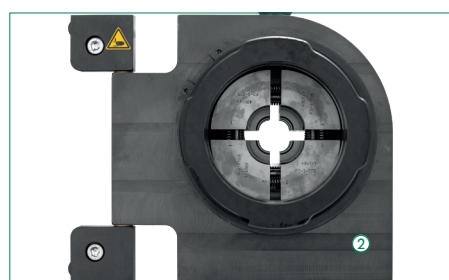
Operating elements of the tube forming machine



Noise-reducing tool tray with durable rubber mat



Lateral handle bars and rubber machine feet with suitable clearance height



Open clamping head with clamping jaws inserted



Inserting the tube shaper into the tool holder – with no tools required



Electrical connections

Cloud connection allows preventive maintenance via remote access and facilitates the documentation of assembly processes



Tube forming machines type SFO-F-A are equipped at the factory with a built-in module for direct connection to a cloud operated by STAUFF. This solution is realised with an integrated SIM card which can be used in all industrial regions of the world.

This enables software updates, for example, without having to connect the machine to a local network on site. Parameter sets, which have been determined by STAUFF for non-standard tube materials can also be transferred quickly and directly to the machine in this way.

Customers are given access to the cloud via a protected online portal, where they can get detailed information on the assembly processes performed, among other things.

The required data security is guaranteed by encryption in both directions.

STAUFF Form EVO Tube Forming Machine Type SFO-F-A-A-IOT

Characteristics

Performance

- Constant high process safety, reliability and reproducibility by the position-control of the machine, which performs the shaping process following a manual start and monitors it by means of stored parameters
- Maximum efficiency thanks to short cycle times – ideal for series production
- Quick and simple replacement of tube shapers (with bayonet lock) and clamping jaws when changing the tube dimensions – with no tools required
- Potential risk of confusion and assembly errors caused by incorrect assignment can virtually be ruled out by the clear labelling of all assembly tools
- Surface-friendly clamping of the tube during the forming process
- Counters for lot/batch sizes and total quantities (separated by tool size)
- Predefined menu languages: English, German, French and Italian
- High degree of user comfort with clear information displayed on the operating panel

Design

- ① Robust and ergonomically designed machine housing
- ② Easily accessible clamping head for simple positioning of the clamping jaws and optimised assembly area with approx. 110 mm distance from the tube axis to the interfering edge of the machine housing, which allows processing of tubes with low bending radii or complex geometries
- ③ Noise-reducing tool tray with durable rubber mat
- ④ Lateral handle bars as attachment points for transport (e.g. with lifting belts)
- ⑤ Secure positioning thanks to flexible rubber machine feet
- ⑥ Type plate, with technical data, serial number, year of manufacture etc.

Technical Data

Area of Application

- **Function:** Cold forming of seamless cold drawn precision steel tubes acc. to EN 10305-1 (materials E235, E355) and stainless steel tubes (material 1.4571 / AISI 316 Ti)

Parameters for alternative materials can be added by the manufacturer, if required. Please contact STAUFF for details.

- **Operating principle:** Tube forming with combined pressure/position-control
- **Series and dimensions:** Light Series (L): 6 x 1,5 mm to 42 x 4 mm
Heavy Series (S): 6 x 1,5 mm to 38 x 6 mm

Dimensions / Weight

- **Dimensions (W x D x H):** 850 mm x 890 mm x 330 mm with lateral handle bars (detachable)
- **Distance from the tube axis to the interfering edge of the machine housing:** 110 mm
- **Clearance height:** 65 mm (height of the machine feet) enables simple and safe transport using a forklift or pallet jack
- **Weight:** 210 kg (including operating fluid, excluding forming tools)

Materials

- **Machine frame:** Aluminium
- **Machine housing:** Steel, painted
- **Tool tray:** NBR (Perbunan®)
- **Machine feet:** Natural rubber
- **Form rings:** Steel, zinc/nickel-plated
- **Form rings (seal):** FKM (Viton®)

Operating Elements

- ⑦ Operating panel for display and selection of all relevant settings and forming parameters
- ⑧ Button for definite confirmation of entries made on the operating panel
- ⑨ Status light to indicate readiness for operation and running assembly processes

Safety Devices

- ⑩ Main power switch (can be secured against unauthorised actuation when required)
- ⑪ Separate emergency stop button to immediately stop all machine movements

Connections (at the back of the machine)

- ⑫ Electrical connection according to IEC 60309 CEE 16A (cable length: 4 m)
- ⑬ Connection for External Foot Control Switch Type SFO/PRC-POC-FS
- ⑭ Ethernet connection (RJ45) for maintenance and data input by the manufacturer
- ⑮ Aerial IoT Gateway for preventive maintenance via remote access and facilitates the documentation of assembly processes

Tube Forming Tools

- ⑯ Clamping Jaws FI-FB with clear identification of the tube dimension
- ⑰ Version of a Tube Shaper FI-FST with Internal Tube Support FI-ID
- ⑱ Tube Shaper FI-FST with clear identification of the tube dimensions

Motor Configuration

- **Power supply:** 400 V AC @ 50 Hz - 3 phases
460 V AC @ 60 Hz - 3 phases
- **Current consumption:** 2,55 A
- **Connected load:** 1,0 kW
- **Electrical connection:** Phase reversing plug according to IEC 60309 CEE 16A
- **Cable length:** 4 m

Alternative motor configurations and plug types are available on request. Please contact STAUFF for details.

Hydraulic System

- **Operating fluid:** Hydraulic oil Shell Tellus S2 MA 46 or equivalent (filled and ready for operation when delivered)
- **Fluid volume:** 6,1 litres
- **Max working pressure:** 700 bar

Operating Conditions

- **Storage temperature:** -10°C ... +70°C
- **Ambient temperature:** +15°C ... +35°C
- **Ambient conditions:** Dry, no condensing humidity, operation in horizontal position only less than 69 dB(A) as per EN ISO 11202 at full-load operation with maximum tube dimensions
- **Noise emission:**



STAUFF Maintenance Contracts

Please contact STAUFF for a maintenance contract, that provides optimum service for your STAUFF Tube Forming Machine.



STAUFF Machine Rental

Please contact STAUFF for a rental machine and further details of what this service can offer.

STAUFF Form EVO Tube Shapers ▪ Type FI-FST
STAUFF Form EVO Internal Tube Supports ▪ Type FI-ID



Materials / surface finishings: **HR Steel**, uncoated, hardened

Tube OD mm	Tube Wall Thickness mm	Weight per piece kg ca.	Ordering Codes	
			Tube Shapers	Internal Tube Supports
6	1,5	1,95	FI-FST-06L/S-F2-S-A	
	2,0			
8	1,5	1,97	FI-FST-08L/S-F2-S-A	
	2,0			
	2,5			
10	1,5	1,98	FI-FST-10L/S-F2-S-A	
	2,0			
	2,5			
	3,0			
12	1,5	1,99	FI-FST-12L/S-1.5-F2-S-A	FI-ID-12x1.5-HR/2
	2,0		FI-FST-12L/S-2/2.5/3-F2-S-A	
	2,5			
	3,0			
15	1,5	2,0	FI-FST-15L-F2-S-A	FI-ID-15x1.5-HR/2
	2,0			FI-ID-15x2.0-HR/2
	2,5			FI-ID-15x2.5-HR/2
16	1,5	2,04	FI-FST-16S-2/2.5-F2-S-A	FI-ID-18x2.5-HR/2
	2,0			FI-ID-16x2.0-HR/2
	2,5			FI-ID-16x2.5-HR/2
	3,0		FI-FST-16S-3/4-F2-S-A	
	4,0			
18	2,0	1,97	FI-FST-18L-2/2.5-F2-S-A	FI-ID-18x2.0-HR/2
	2,5			FI-ID-18x2.5-HR/2
	3,0		FI-FST-18L-3-F2-S-A	
	4,0			
20	2,0	1,98	FI-FST-20S-2/2.5-F2-S-A	FI-ID-20x2.0-HR/2
	2,5			FI-ID-20x2.5-HR/2
	3,0		FI-FST-20S-3/3.5/4-F2-S-A	
	3,5			
	4,0			
22	2,0	1,95	FI-FST-22L-2/2.5-F2-S-A	FI-ID-22x2.0-HR/2
	2,5			FI-ID-22x2.5-HR/2
	3,0		FI-FST-22L-3/3.5-F2-S-A	
	3,5			
25	2,0	1,96	FI-FST-25S-2/2.5-F2-S-A	FI-ID-25x2.0-HR/2
	2,5			FI-ID-25x2.5-HR/2
	3,0		FI-FST-25S-3/3.5/4/5-F2-S-A	
	3,5			
	4,0			
28	2,0	1,96	FI-FST-28L-2/2.5/3-F2-S-A	FI-ID-28x2.0-HR/2
	2,5			FI-ID-28x2.5-HR/2
	3,0		FI-FST-28L-3.5/4-F2-S-A	FI-ID-28x3.0-HR/2
	3,5			
	4,0			
30	2,5	1,95	FI-FST-30S-2.5/3-F2-S-A	FI-ID-30x2.5-HR/2
	3,0			FI-ID-30x3.0-HR/2
	4,0		FI-FST-30S-4/5/6-F2-S-A	
	5,0			
	6,0			
35	2,5	2,0	FI-FST-35L-2.5/3-F2-S-A	FI-ID-35x2.5-HR/2
	3,0		FI-ID-35x3.0-HR/2	
	4,0		FI-FST-35L-4/5-F2-S-A	
	5,0			
38	3,0	1,82	FI-FST-38S-3/4-F2-S-A	FI-ID-38x3.0-HR/2
	4,0			FI-ID-38x4.0-HR/2
	5,0		FI-FST-38S-5/6-F2-S-A	
	6,0			
42	3,0	1,94	FI-FST-42L-F2-S-A	FI-ID-42x3.0-HR/2
	3,5			FI-ID-42x3.5-HR/2
	4,0			FI-ID-42x4.0-HR/2

Please note:

The selection chart is only applicable in conjunction with seamless cold drawn precision steel tubes according to EN 10305-1 (materials E235, E355) and stainless steel tubes (material 1.4571 / AISI 316 Ti).

Please consult STAUFF for information regarding the processing of tubes made from stainless steel and other materials.

External Foot Control Switch
Type SFO/PRC-POC-FS



- Enables the operator to trigger assembly processes from a larger distance to the machine (cable length: 7 m)

STAUFF Form EVO Oil
Type Oel-Stauff-Form-1L

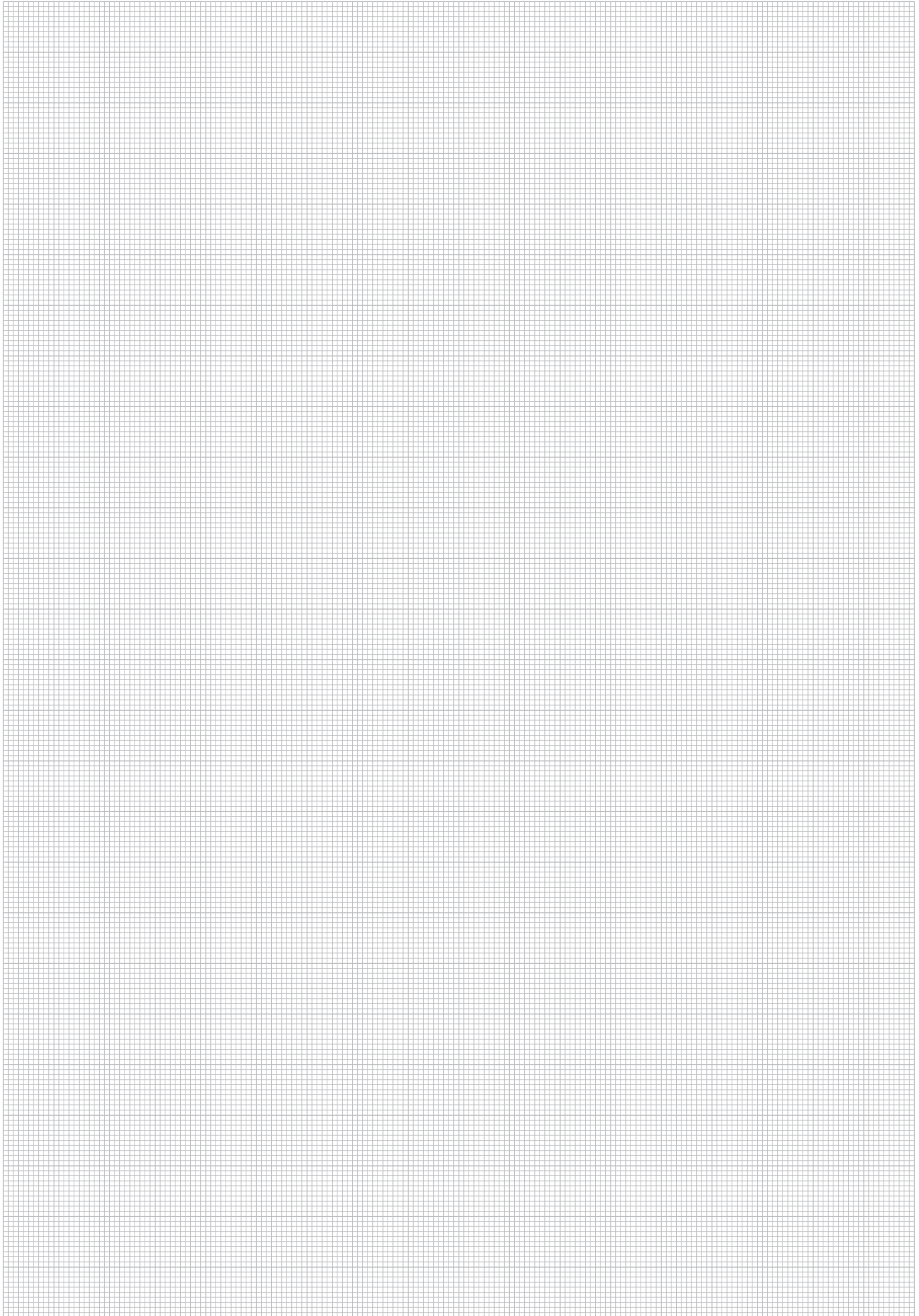


- Enables faultless, mechanical tube forming with STAUFF Form EVO machines when using stainless steel tubes

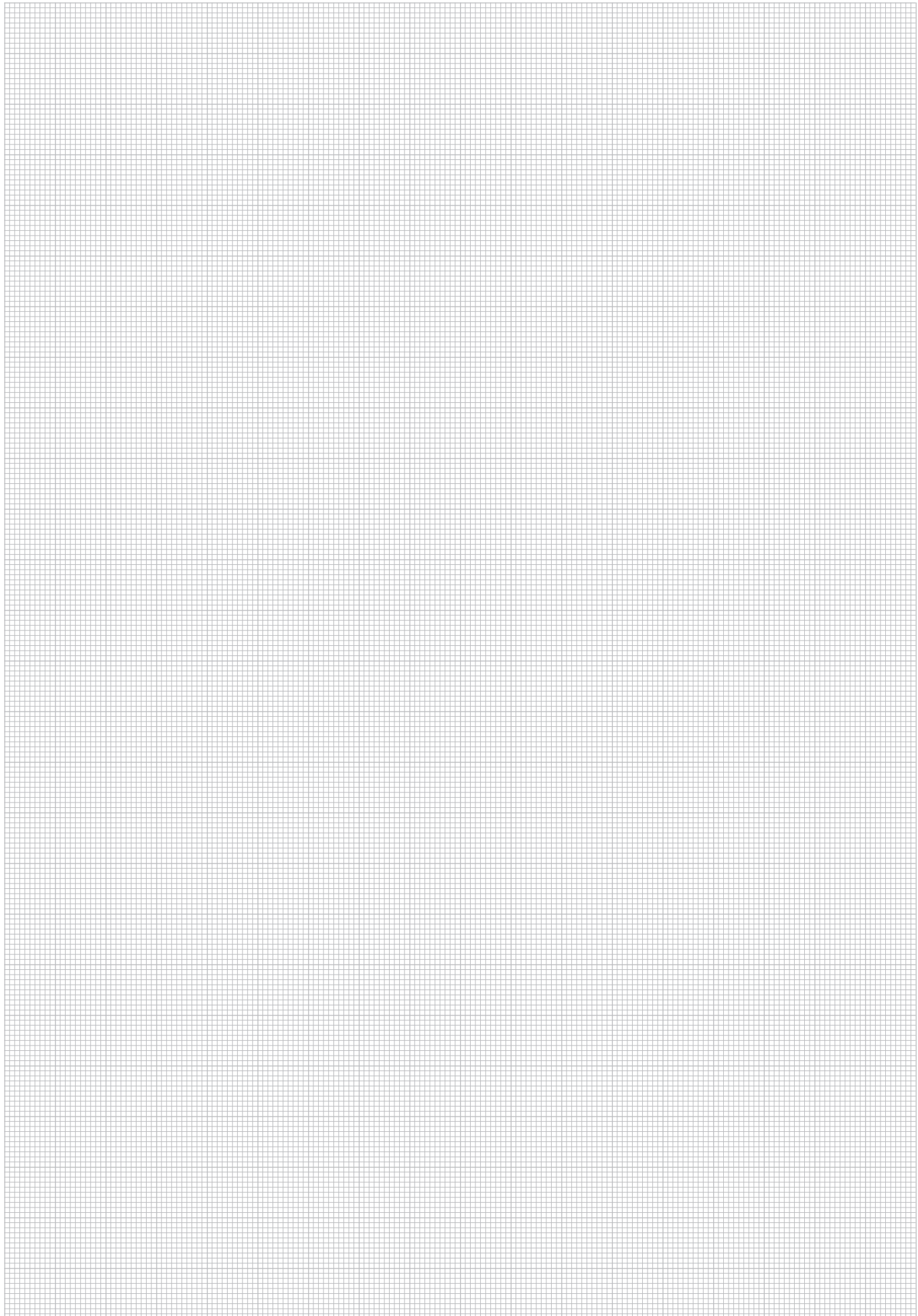
STAUFF Oil with brush
Type SPR-PRC-H-M-OS



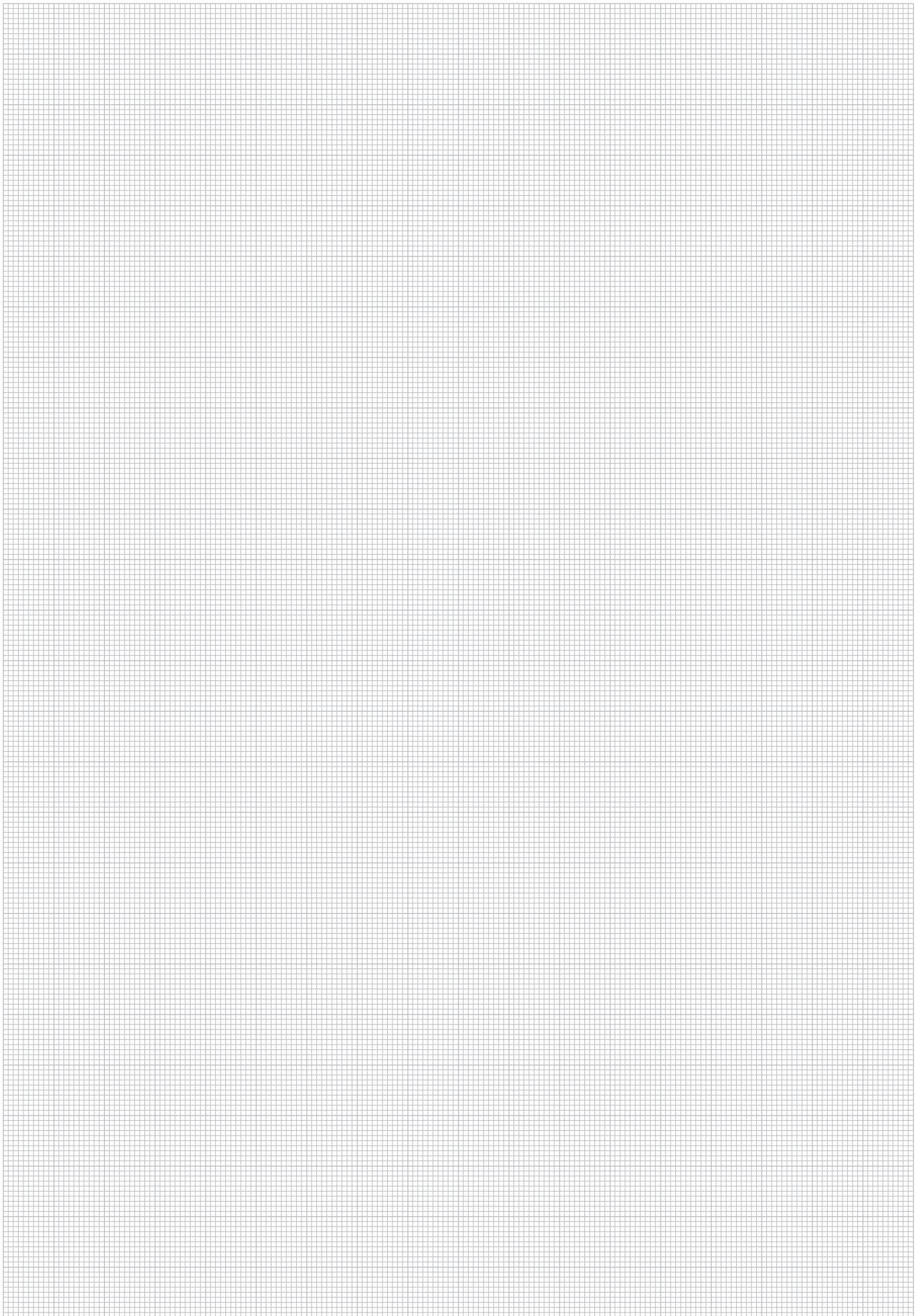
- Enables faultless, mechanical tube forming with STAUFF Form EVO machines when using stainless steel tubes



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